

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027252**Date Inspected:** 29-Feb-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

QA NDT (Interior)

This QA Inspector performed a Magnetic Particle (MT) Inspection on "A" deck Longitudinal Stiffener (ALS) #5 at 13W/14W on the interior of the OBG. This QA Inspector performed the yoke method in conformance with ASTM E 709 and the standard of acceptance with D1.5 section 6.26. This QA Inspector noted that no rejectable indications were found at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work at this location appeared to be in general conformance with the contract specifications.

13W/14W-ALS #5 (Interior)

This QA Inspector randomly observed ABF welder Richard Garcia utilize a propane burner to pre-heat the TC-P4-GF Partial Penetration Joint (PJP) to 200° F prior to performing Shielded Metal Arc Welding (SMAW) in the 4G overhead position on the flange plate to rib stiffener at 13W/14W-ALS #5 on the interior of the OBG. The 18mm flange plates weld # WD751K and WD751L, were tacked into position to the 30mm Longitudinal Stiffener #5 where planar offset measurements were taken and recorded by QC Inspector Sal Merino. Upon acceptance of the fit up the pre-heat temperatures were measured and the E9018-M H4R Electrodes were verified as being from a new container. The welder was observed cleaning between passes and maintaining continuous heat throughout

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the shift. QC Inspector Sal Merino was observed monitoring the welding and the parameters to ensure conformance to ABF-WPS-D1.5-1162-4 and measuring the inter-pass temperatures between passes. This QA Inspector made subsequent observations throughout the shift and noted that the work was in progress and appeared to be in general conformance with the contract specifications.

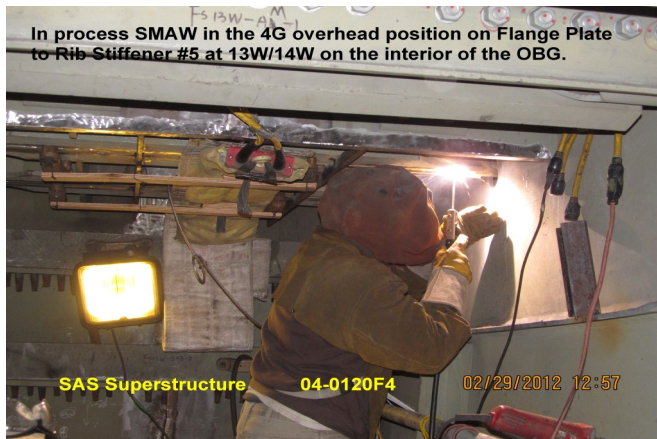
QC NDT (Exterior)

This QA Inspector randomly observed ABF Quality Control Inspector Mr. John Pagliero performing Ultrasonic Testing (UT) inspection on "A" deck lifting lug holes #3 and 4 at 13W PP118.5 W3 on the exterior of the OBG. This QA Inspector observed that Mr. Pagliero found no rejectable indications and the work was acceptable. The deck at this location is 20mm thick and is a Seismic Performance Critical Member (SPCM).

It was noted by this QA Inspector that due to inclement weather on this date that a limited amount of welding was performed at select locations.

Summary of Conversations:

The were no pertinent conversations to report.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
